

## CHAPTER V LOCATING POINTS AND ADJUSTABLE STOPS

The locating points in a jig usually consist of finished pads, bosses, seats, or lugs, cast solid with the jig, as illustrated in Fig. 1. In this engraving the surfaces marked / are the locating points, which bring the piece to be machined in correct relation to the bushings guiding the drills, or to the gages to which other cutting tools may be set. This method of locating the work is satisfactory when the work done is finished in a uniform way and where there is very little variation in the parts inserted in the jig^

Pins and Studs used as Locating Means. Another commonly used method for locating the work in jigs is by means of dowel pins, as shown at *A* and *B* in Fig. 2. The sides of the dowel pins which rest against the work are usually flattened, as indicated, so as to give more bearing than a mere line contact with the pins could give, and, at the same time, prevent too rapid wear on the locating pins, as would be the case if the work bear against the pins along a line only.

Sometimes pins or studs are inserted in jigs to act as locating points, instead of having lugs cast directly on the jig as shown in Fig. 1. A case where a pin is used for this purpose is shown in Fig. 3, where *B* is the body of the jig, *A* the pin inserted to act as a locating and resting point, and *C* the work located against this point. Locating pins of this character should always be provided with a shoulder or collar, so that they will firmly resist the pressure of the work they support, without possibility of moving in the hole in which they are inserted.

Locating by Means of V-blocks. A common method of locating cylindrical pieces or surfaces is that of placing the cylindrical surface in a V-block, as shown in Fig. 4. This V-block, as a rule, is stationary, and is held in place by screws